

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000045**Date Inspected:** 11-Nov-2006**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**Witness:** **Procedure Qualification Record**  
**Welding** **NDT**

**Welder Qualification**  
**Mechanical Testing, describe:**

**Fracture Critical****Index Lot #:** B72-052-06**Bridge No:** 34-0006**Welder:** Lei Li Chao**Witness Lot #:** N/A**Component:** N/A**ID #:** Lei Li Chao**Joint Description:** T-Joint

N/A

**WPS ID #:**

WPS B-T-2133

N/A

**Base Metal:** A709M 345

N/A

**PQR ID #:**

HP-2006112

N/A

**Thickness:** 26mm

N/A

**Process:**

FCAW

N/A

**Electrode Spec/Class:** A5.20/E71T-1

N/A

**Positions:**

3F

N/A

**Backing Material:** A709M

N/A

**CWI:**

Liu Liu

N/A

**Average Amps:** 162.7

N/A

**AWS Code:**

AWS D1.5 (2002)

N/A

**Average Volts:** 23.9

N/A

**Applicable Sec:**

5.12 Min &amp; 12

N/A

**Travel Speed:** 123.6mm/min

N/A

**Heat Input:**

1.89kilojoules/mm

N/A

**Preheat:** 52.7C

N/A

**Summary of Items Observed:**

This was a 3F (Vertical) Fillet weld test plate consisting of the maximum size single-pass and minimum size multi-pass fillet welds.

**Summary of Conversations:**

See 6031 report

**Observed welding,testing or results:**

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

**Inspected By:** Berger,Bruce

Quality Assurance Inspector

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## WELDING WITNESS REPORT

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**Reviewed By:** Lowry,Patrick

QA Reviewer